

Work Order ID 81920

March-20-12 4:24:59 PM

81920

Page 1

Item ID: D3264-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 20/03/2012 Start Qty: 6.00

Cust Item ID:

Required Date: 03/04/2012 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3264

Rev A

100

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.700" LONG

25 12-04-09 (r3)

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOILIO FA447

FOILIO REV: AA

DWG REV: A

DEBURR AS PER DWG

28 101 12/04/22 (PTO)

W/O: 81920		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3264-1 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: 12/27 Date: 12/04/27
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: 12/4/27 Date: 12/4/27

NCR: 12-1385		WORK ORDER NON-CONFORMANCE (NCR) 176.89						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/22	110	wall thickness R.C. Process	<u>W</u> <u>12/04/22</u>	SCRAP. TOO THIN, PER SR-D412-706-1 Q12.04.24	<u>AF</u> 12/04/23	<u>SR</u> 12/04/24	<u>W</u> 12/26/24	<u>S</u> 12/09/24
		reject Qty 1						

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81920

81920

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March-20-12 4:24:59 PM

Item ID: D3264-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bracket
 Start Date: 20/03/2012 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 03/04/2012 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo	0.00 START: 7:30 OVERT: 320 FINISH: 8:00				2X	0		M-1 12/04/25
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				2x	0		Unblock 12/04/25
170 *170* Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00				2x			SP 12-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81920***81920***

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March-20-12 4:24:59 PM

Item ID: D3264-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 20/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/4/25

1204-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 81920

81920

Parent Item: D3264-1

D3264-1

Parent Item Name: Bracket

Start Date: 20/03/2012

Required Date: 03/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.09.02New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.250X04.50 0		Purchased	No				f	6.2417		3			

M6061T6B1 250X04 500

**

25 12-04-19

6061-T6 Bar 1.25 X 4.50

Location

Loc Qty

Loc Code

MAT004

6.2417

112628

0.7417

119230

5.5

3 1.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81920
Description: Bracket		Part Number:	D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.686	✓		SLO8	VERN
0.063	+/-0.010	0.063	✓			
0.125	+/-0.010	0.117	✓			
0.875	+0.010/-0.020	0.870	✓			
0.062	+/-0.010	0.065	✓			
R0.03	+/-0.030	R.03	✓		Rad gauge	
R0.13	+/-0.030	R.130	✓		Rad gauge	
1.00	+/-0.030	1.002	✓		SLO8	VERN
0.125	+/-0.010	0.127	✓			
0.600	+/-0.010	0.601	✓			
4.000	+/-0.005	3.999	✓			
0.750	+/-0.010	0.750	✓			
Ø0.194	+0.005/-0.000	Ø0.196	✓			
5.50	+/-0.030	5.503	✓			
0.125	+/-0.010	0.127	✓			
0.063	+/-0.010	0.065	✓			
R0.25	+/-0.030	R.250	✓		Rad gauge	
4.27	+/-0.030	4.270	✓		SLO8	VERN
R0.30	+/-0.030	R.030				

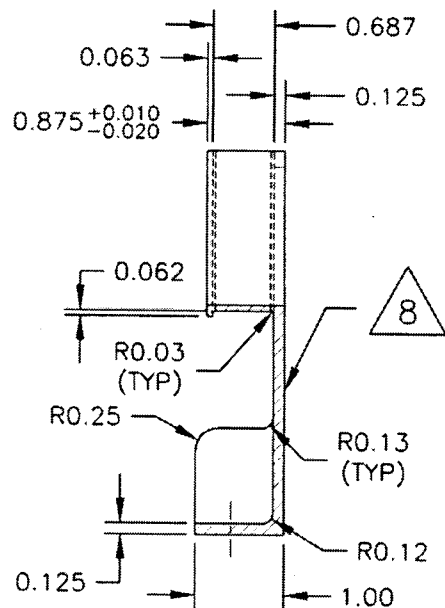
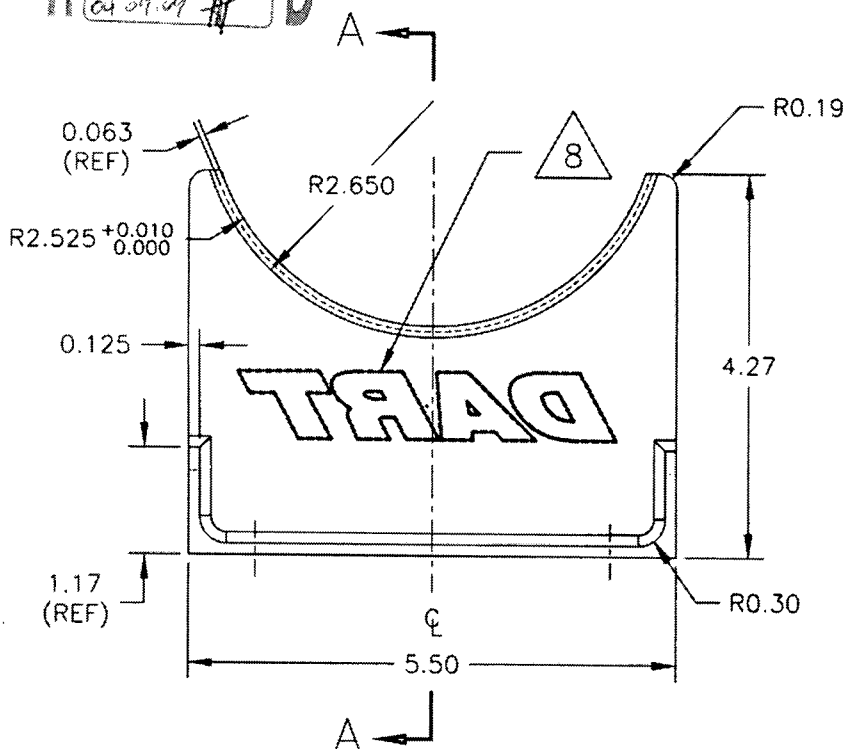
Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12/04/22	Date:	12/04/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM	
C	07.10.10	Tolerance for 0.875 revised	KJ/EC/DD	<i>[Signature]</i>

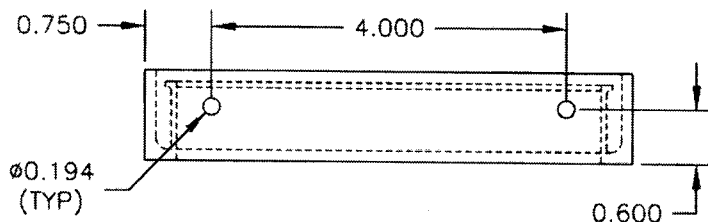


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED
04.09.09 #



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81926
12/03/21
MCS

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